

Work Order ID 65932

Thursday, January 27, 2011 1:07:08 PM

Page 1

Item ID: D4032-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 2/14/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *11-01-27* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4032

D

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1/27/11 *(1)**1* *11/02/11**(H)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

P/P 65936

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF 11-02-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, January 27, 2011 1:07:05 PM

Page 1

Work Order ID: 65932

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)







Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.12.02 verified by:EC IPP Rev:B as per PA3 DD 10.03.10 verified by:EC IPP Rev:C as per RevA DD 10.03.23 verified by:EC IPP Rev:D as per dwg revC DD 10.04.20 verified by:EC IPP Rev:E as per dwg revD DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530  Handle Weldment		Manufactured	No			100	Each	11.0000	1 	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST506		11				64443			
					64443	3							
					65094	8							
D2535  Spring		Manufactured	No			100	Each	54.0000	2 	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		54							
					58331	14				58331			
					64280	40							
D2537  Bushing		Manufactured	No			100	Each	26.0000	2 	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		26							
					64064	26				64064			

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Thursday, January 27, 2011 1:07:05 PM

Page 2

Work Order ID: 65932

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3917-3

Manufactured No

100

Each

18.0000

6

6



Washer

Location

Loc Qty

Loc Code

ST095

17

64589

17

ST096

1

57144

1

64589

D3953-3

Manufactured No

100

Each

7.0000

2

2



Gas Spring Stud, Lid

Location

Loc Qty

Loc Code

ST096

7

65052

7

65052

D3953-7

Manufactured No

100

Each

10.0000

2

2



Spring Spacer

Location

Loc Qty

Loc Code

ST096

9

65053

9

ST103

1

65336

1

65053

Thursday, January 27, 2011 1:07:05 PM

Shop Packet Print

Page 2

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Page 3

Work Order ID: 65932

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-9

Manufactured No

100

Each

22.0000

2

2



Gas Spring Washer



65136

Location

Loc Qty

Loc Code

ST096

17

65136

17

ST100

3

64450

3

ST103

2

60008

2

D3953-17

Manufactured No

100

Each

33.0000

2

2



Gas Spring Spacer



65138

Location

Loc Qty

Loc Code

ST097

31

65138

31

ST101

2

57143

1

64021

1

D3953-19

Manufactured No

100

Each

20.0000

1

1



Gas Spring Bracket



64810

Location

Loc Qty

Loc Code

ST

2

59213

2

ST097

18

64810

18

64810

Thursday, January 27, 2011 1:07:05 PM

Shop Packet Print

Page 3

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Parent Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-21

Manufactured No

100

Each

9.0000

1

1



Gas Spring Bracket

Location

Loc Qty

Loc Code

ENG

5

56407

5

ST102

4

57145

2

59214

2

D3969-3

Manufactured No

100

Each

18.0000

1

1



Spring (Basket Lid)

Location

Loc Qty

Loc Code

ST272

18

64285

18

D4017-041

Manufactured No

100

Each

0.0000

1



Short Basket Base Assembly (350)

D4018-041

Manufactured No

100

Each

0.0000

1

1



Short Basket Lid Assembly (350)

AN3-14A

Purchased No

100

Each

64.0000

4

4



Bolt

Location

Loc Qty

Loc Code

ST351

64

114941

14

115108

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Thursday, January 27, 2011 1:07:05 PM

Page 5

Work Order ID: 65932

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-16A	Purchased	No	100	Each	102.0000	2	2	
Bolt								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST352	102	
114752	52	
116419	50	

114702

AN4-12	Purchased	No	100	Each	26.0000	3	3	
Bolt								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST357	26	
114784	2	
116419	24	

116419

AN5-17A	Purchased	No	100	Each	140.0000	4	4	
Bolt								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST339	140	
116003	40	
116590	100	

116003

AN310-4	Purchased	No	100	Each	18.0000	3	3	
NUT								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST324	18	
116075	18	

116075

Thursday, January 27, 2011 1:07:06 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D4032-041




Parent Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00




Required Qty: 1.00

AN310C4	Purchased	No	100	Each	10.0000	2	2	
								
Nut								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST349	10	
-------	----	--

114306	10	
--------	----	--

MS21042L3	Purchased	No	100	Each	3,053.000	6	6	
								
Nut								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST300	3053	
-------	------	--




114784	9	
--------	---	--

115835	544	
--------	-----	--

116391	900	
--------	-----	--

116540	800	
--------	-----	--

116549	800	
--------	-----	--

MS21042L5	Purchased	No	100	Each	1,235.000	4	4	
								
Nut								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST139	26	
-------	----	--

114813	26	
--------	----	--

ST300	1209	
-------	------	--

115156	5	
--------	---	--

115594	500	
--------	-----	--

116104	8	
--------	---	--

116105	496	
--------	-----	--

116548	200	
--------	-----	--

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 7

Thursday, January 27, 2011 1:07:06 PM

Work Order ID: 65932

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

MS24665-151

Purchased

No

100

Each

566.0000

3

3



Cotter Pin

LocationLoc QtyLoc Code

ST309

566

17566

566

17566

MS24665-300

Purchased

No

100

Each

28.0000

2

2



Cotter Pin

LocationLoc QtyLoc Code

ST309

28

110123

28

110123

NAS1149F0432P

Purchased

No

100

Each

94.0000

6

6



Washer

LocationLoc QtyLoc Code

ST275

94

112940

92

114405

1

116169

1

110123
1116737

NAS1149C0432R

Purchased

No

100

Each

154.0000

2

2



Washer

LocationLoc QtyLoc Code

ST297

154

114292

36

114742

27

116304

91

1116737
1116737

Thursday, January 27, 2011 1:07:06 PM

Shop Packet Print

Page 7

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Picklist Print

Page 8

Thursday, January 27, 2011 1:07:06 PM

Work Order ID: 65932



Parent Item: D4032-041



Parent Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

100

Each

278.0000

8

8



WASHER



Handwritten signature

Location

Loc Qty

Loc Code

ST275

278

18057

278

18057

NAS1149F0563P

Purchased

No

100

Each

150.0000

4

4



Washer



Handwritten signature and date 1/24/11

Location

Loc Qty

Loc Code

ST298

150

114576

150

1114576

Thursday, January 27, 2011 1:07:06 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

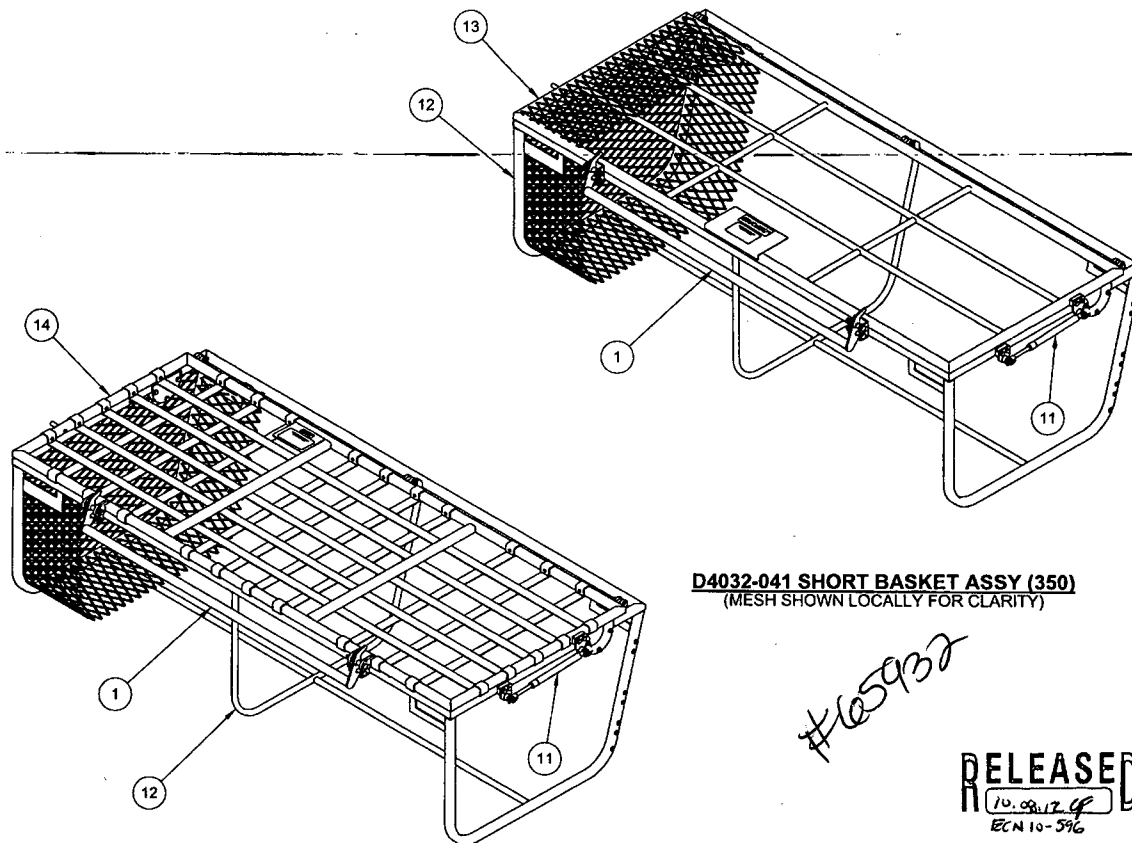
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NOTE: Date & initial all entries

ITEM	-041 QTY.	-043 QTY.	P/N	DESCRIPTION
	X		D4032-041	SHORT BASKET ASSY (350)
		X	D4032-043	SHORT BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	6	6	D3917-3	WASHER
5	2	2	D3953-3	GAS SPRING STUD, LID
6	2	2	D3953-7	GAS SPRING SPACER
7	2	2	D3953-9	GAS SPRING WASHER
8	2	2	D3953-17	GAS SPRING SPACER
9	1	1	D3953-19	GAS SPRING BRACKET
10	1	1	D3953-21	GAS SPRING BRACKET
11	1	1	D3969-3	SPRING
12	1	1	D4017-041	SHORT BASKET BASE ASSY (350)
13	1		D4018-041	SHORT BASKET LID ASSY (350)
14		1	D4019-041	LIGHT LID SHORT BASKET ASSY
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	2	2	NAS1149C0432R	WASHER
29	8	8	NAS1149F0332P	WASHER
30	4	4	NAS1149F0563P	WASHER



D4032-041 SHORT BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

D4032-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 56 lbs APPROX
-043: 45 lbs APPROX

D	QTY FOR ITEMS #28, #29 & #30 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D6-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3)	MB	10.07.23
C	AN5-21A BOLT WAS AN5-19A BOLT: BOM & (D3-3)	JPH	10.04.06
B	ITEM 15 D4086-232 & 16 D4086-243 REMOVED; ITEM RENUMBERED AS REQD. PLACARDS REMOVED (C6-2); TOP VIEW DETAIL REMOVED (C2-2)	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	DESIGN	DATE	10.07.23
DRAWN	DESIGN	DATE	10.07.23
CHECKED	DESIGN	DATE	10.07.23
MFG. APPR.	DESIGN	DATE	10.07.23
APPROVED	DESIGN	DATE	10.07.23
DE APPR.	DESIGN	DATE	10.07.23

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4032	REV. D
TITLE SHORT BASKET ASSY (350)	SCALE — NTS
COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
10.09.17
ECN 10-596

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

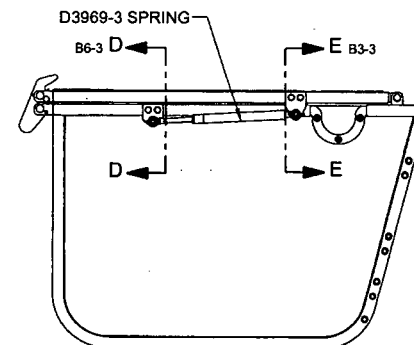
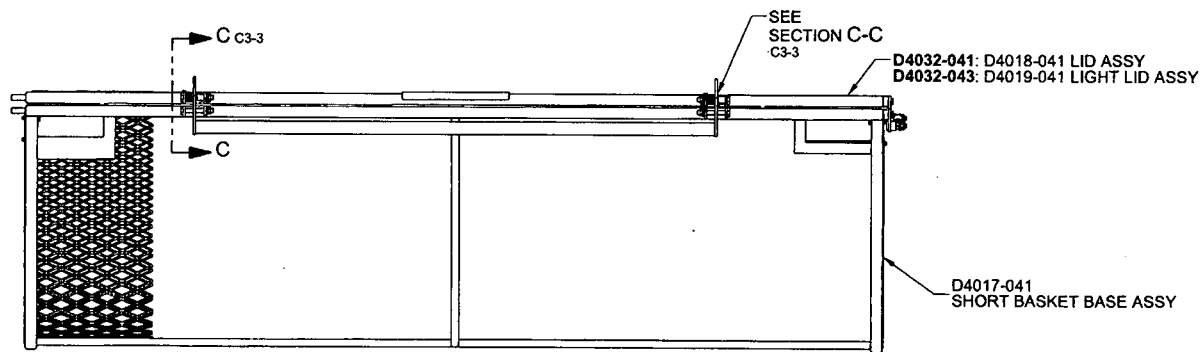
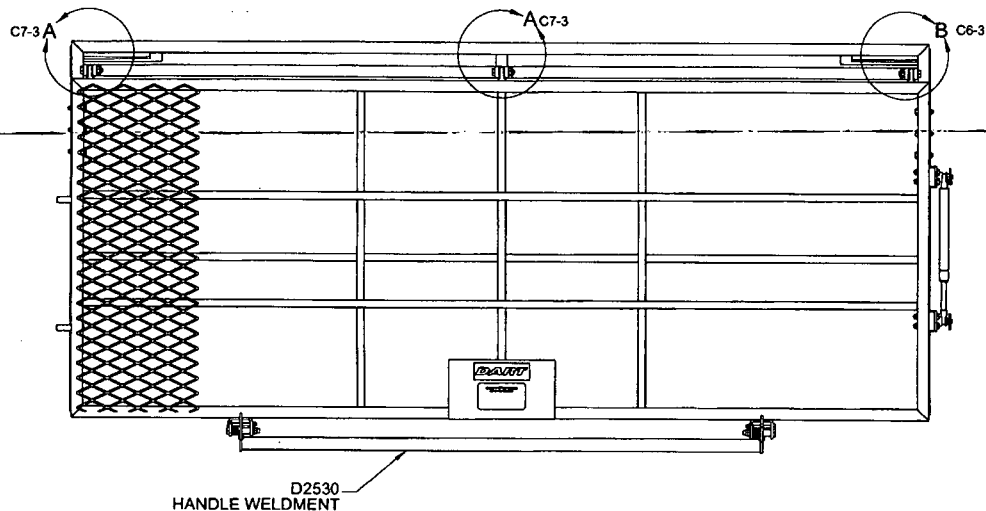
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4032-041 SHORT BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4032-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFS	DRAWING NO.	REV. D
CHECKED	JFS	D4032	SHEET 2 OF 3
MFG. APPR.	JFS	TITLE	SCALE
APPROVED	JFS	SHORT BASKET ASSY (350)	NTS
DE APPR.	JFS	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.07.23		

8 7 6 5 4 3 2 1

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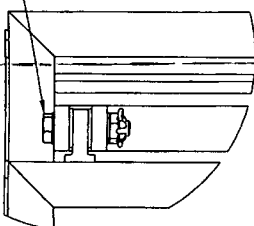
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

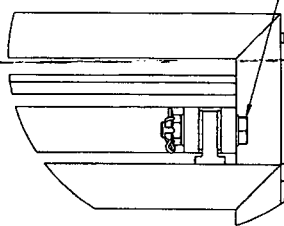
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



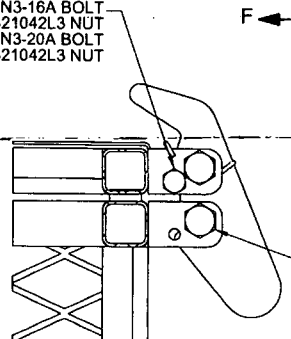
DETAIL A D8-2
D8-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



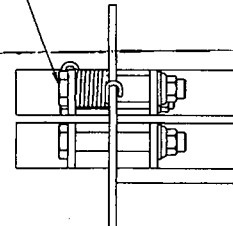
DETAIL B D4-2

D4032-041: AN3-16A BOLT
MS21042L3 NUT
D4032-043: AN3-20A BOLT
MS21042L3 NUT



SECTION C-C B5-2
B7-2

D4032-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT
D4032-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

D2530 WELDMENT
REF

C1-3 F

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
10.07.23

DESIGN	AUS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JFS JIM	D4032	SHEET 3 OF 3
APPROVED	JIM	TITLE	SCALE
DE APPR.	J	SHORT BASKET ASSY (350) NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

*NOTE: Date & initial all entries